



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB23003267-7
Job Sheet 197219



Part No: RB23003267-7

Job Qty: 2 pcs *4 pcs*

Part Name: #27 Drill Bit



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/5/19

Type: Stock

Description:

Note: DWG RB23003267 Rev.4 IPP Rev. A 19.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Small Fab - 1	2 pcs	8/5/19	8/5/19	0.00	0.25	Small Fab - 1	<i>MCC</i>
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
110	QC 5	2 pcs	8/5/19	8/5/19	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
120	Small Fab - 2 - B4B	2 pcs	8/5/19	8/5/19	0.00	0.20	Small Fab - 1 - B4B	<i>JUL 29 2019</i>
							Small Fab - 2 - B4B	
							Small Fab - 3 - B4B	
							Small Fab - 4 - B4B	
							Small Fab - 5 - B4B	
							Small Fab - 6 - B4B	
							Small Fab - 7 - B4B	



Container No: S199676



Part: RB23003267-7

Job No: 197219

Serial No/Batch: S199676

Revision: 4

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 07/22/19

125 QC 5	2 pcs	8/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
130 Packaging 3-1 - Stock - B4B	2 pcs	8/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	2 pcs	8/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
28
9-89

DAS
21
9-89

JUL 29 2019

Part Op 100 - Assemble as per drawing using LOC TITE multipurpose epoxy.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 120 - Laser engrave as per drawing.

125 - QC5- Inspect part completeness to step on W/O

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB23003267-7A	#27 Drill Bit	2 pcs (1 ea)	100-Small Fab - 1	5199034
RB23003267-7B	Block	2 pcs (1 ea)	100-Small Fab - 1	5160906

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RB23003267-7A	2	0	0
	RB23003267-7B	2	4	0

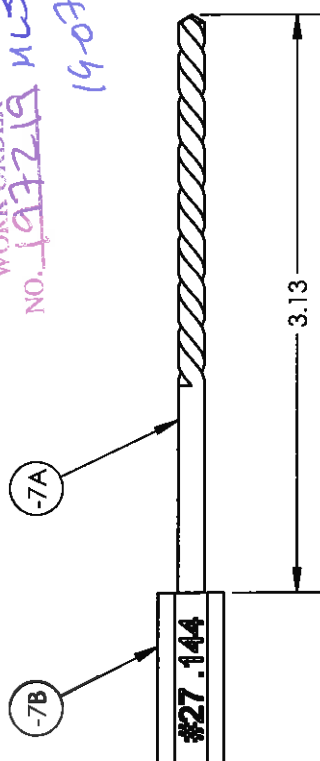
Part Specifications

Specifications could not be found.

Plex 7/3/19 8:45 AM Dart.lajeunesse.marie

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

WORK ORDER
NO. 197219 WLS
140703



NOTE:
ASSEMBLE WITH EPOXY.



POWER TURBINE CLEANING KIT

DWG NO.	RB23003267-7		REV	4
MAT'L	UNLESS OTHERWISE SPECIFIED			
MEAT	DIMENSIONS ARE IN INCHES			
FINISH	FRACTIONS 3/16			
SPEC	.XXX ± .005			
	ANGLES ±.5°			
	SURFACES ±.125			
DRAWN BY:	1. BREAK ALL SHARP EDGES			
CHECKED:	.015 x .45" OR .015R			
OPPS APPR:	2. DIMENSIONAL LIMITS APPLY			
QA APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009			
APPROVED:	USED ON MODEL			
SCALE	1:1	DATE	1/7/2001	SEE NOTE 1, SHEET 1
				SHEET 9 OF 18

#27 DRILL BIT ASSEMBLY

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)																													
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																													
Description Work Order Deviation				Completed By																															
Lead hand / Supervisor				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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